



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D206-642-541
Job Sheet 196216



Part No: D206-642-541

Job Qty: 1 pcs

Part Name: Repl.Skid.,High Gear,Std Wearplates Fits LH/RH, DART Tri-Bag Float Comp.



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/10/19

Job Tracking No:

Due Date: 7/19/19

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: DWG REV G IPP Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC IPP Rev:F 08-06-02 add comment DD verified by:EC IPP Rev:G 08-10-09 revise details DD verified by:EC IPP REV:H 13.09.05 CHG004/ ECN13-634 DD VERF:JLM IPP REV:I 14.04.28 AS PER ECN14-520 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1 pcs	7/19/19		0.00	2.17	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
114	QC 5	1 pcs	7/19/19		0.00	0.00	QC 5 - 10		JUL 02 2019
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19	DAS 24	
							QC 5 - 22	9-89	
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
116	QC 10	1 pcs	7/19/19		0.00	0.00	QC 10 - 10		JUL 02 2019
							QC 10 - 18	DAS 24	
							QC 10 - 24	9-89	
							QC 10 - 43		



1270 Aberdeen Street
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CANADA
TEL : 1 613 632-5200
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Container No: S194554



Part: D206-642-541

Job No: 196216

Serial No/Batch: S194554

Revision: G

Inspector:

Exp Date:

Instructions: FAA STC SA00475SE 18/10/17, STC SH98-

120 Handfinish - 1-1 Chemical-B4B	1 pcs	7/19/19	0.00 0.68	QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	A JUL 03 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
130 QC 7	1 pcs	7/19/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	BE
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	

150 Skidtubes - 2 - B4B	1 pcs	7/19/19	0.00 2.08	QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				Skidtubes - 1 - B4B	00
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	TF
				Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
160 QC 5	1 pcs	7/19/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	BE
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
170 Skidtubes - 3 - B4B	1 pcs	7/19/19	0.00 2.17	Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	FI MAG
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
180 QC 5	1 pcs	7/19/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	BE
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
190 Skidtubes - 4 - B4B	1 pcs	7/19/19	0.00 2.75	Skidtubes - 1 - B4B	00
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	BE
				Skidtubes - 6 - B4B	

				Skid tubes - 7 - B4B	
200 QC 5	1 pcs	7/19/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	JUL 24 2019 DAS 68
				QC 5 - 9	9-89
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
210 QC 10	1 pcs	7/19/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	DAS
				QC 10 - 50	JUL 24 2019 50
				QC 10 - 58	9-89
220 Handfinish - 2-1 Pressure- B4B	1 pcs	7/19/19	0.00 0.45	QC 10 - 9	
				Handfinish - 2 - 1 - B4B	
				Handfinish - 2 - 2 - B4B	JUL 25 2019
				Handfinish - 2 - 3 - B4B	
230 Spray Paint - 2 - B4B	1 pcs	7/19/19	0.00 0.40	Handfinish - 2 - 4 - B4B	
				Spray Paint - 1 - B4B	19-7-25
				Spray Paint - 2 - B4B	
				Spray Paint - 3 - B4B	
240 QC 14	1 pcs	7/19/19	0.00 0.00	Spray Paint - 4 - B4B	
				QC 14 - 15	JUL 14-8-20
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	
				QC 14 - 9	
				QC 14 - 68	
				QC 14 - 40	
				QC 14 - 19	
				QC 14 - 43	
				QC 14 - 24	
244 Handfinish - 3-1- WingWalk- B4B	1 pcs	7/19/19	0.00 0.50	Handfinish - 3 - 1 - B4B	JUL 19-8-20
				Handfinish - 3 - 2 - B4B	
				Handfinish - 3 - 3 - B4B	
				Handfinish - 3 - 4 - B4B	
				Handfinish - 3 - 5 - B4B	
246 QC 3	1 pcs	7/19/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	

DAS
15
9-89

					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	BEB 19-08-20
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
250 Handfinish - 4-1-Assembly-B4B	1 pcs	7/19/19	0.00 0.45		Handfinish - 4 - 1 - B4B	M 19-8-20
					Handfinish - 4 - 10 - B4B	
					Handfinish - 4 - 11 - B4B	
					Handfinish - 4 - 12 - B4B	
					Handfinish - 4 - 13 - B4B	
					Handfinish - 4 - 14 - B4B	
					Handfinish - 4 - 15 - B4B	
					Handfinish - 4 - 2 - B4B	
					Handfinish - 4 - 3 - B4B	
					Handfinish - 4 - 4 - B4B	
					Handfinish - 4 - 5 - B4B	
					Handfinish - 4 - 6 - B4B	
					Handfinish - 4 - 7 - B4B	
					Handfinish - 4 - 8 - B4B	
260 QC 5	1 pcs	7/19/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	DAS 19 8-20
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
270 Handfinish - 4-2-Assembly-B4B	1 pcs	7/19/19	0.00 0.68		QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					Handfinish - 4 - 1 - B4B	M 19-8-20
					Handfinish - 4 - 10 - B4B	
					Handfinish - 4 - 11 - B4B	
					Handfinish - 4 - 12 - B4B	
					Handfinish - 4 - 13 - B4B	
					Handfinish - 4 - 14 -	

DAS 59 9-89

DAS 19 8-20

			B4B					
			Handfinish - 4 - 15 - B4B					
			Handfinish - 4 - 2 - B4B					
			Handfinish - 4 - 3 - B4B					
			Handfinish - 4 - 4 - B4B					
			Handfinish - 4 - 5 - B4B					
			Handfinish - 4 - 6 - B4B					
			Handfinish - 4 - 7 - B4B					
			Handfinish - 4 - 8 - B4B					
			Handfinish - 4 - 9 - B4B					
280 QC 5	1 pcs	7/19/19	0.00 0.00	QC 5 - 10				
				QC 5 - 12				
				QC 5 - 17				
				QC 5 - 18				
				QC 5 - 19				
				QC 5 - 22				
				QC 5 - 24				
				QC 5 - 3				
				QC 5 - 43				
				QC 5 - 49				
				QC 5 - 51				
				QC 5 - 58				
				QC 5 - 68				
				QC 5 - 9				
				QC 5 - 50				
				QC 5 - 30				
				QC 5 - 40				
							DAS 40	
							AUG 2 6 2019 8-59	
				290 Packaging 3-1 - Stock - B4B	1 pcs	7/19/19	0.00 0.00	Packaging 3 - 1 - B4B
Packaging 3 - 2 - B4B								
Packaging 3 - 3 - B4B								
Packaging 3 - 4 - B4B								
Packaging 3 - 5 - B4B								
Packaging 3 - 6 - B4B								
Packaging 3 - 7 - B4B								
Packaging 3 - 8 - B4B								
Packaging 3 - 9 - B4B								
Packaging 3 - 10 - B4B								
Packaging 3 - 11 - B4B								
Packaging 3 - 12 - B4B								
Packaging 3 - 13 - B4B								
Packaging 3 - 14 - B4B								
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Packaging 3 - 16 - B4B								
Packaging 3 - 17 - B4B								
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Packaging 3 - 21 - B4B								
Packaging 3 - 22 - B4B								
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Packaging 3 - 26 - B4B								
Packaging 3 - 27 - B4B								
Packaging 3 - 28 - B4B								
Packaging 3 - 29 - B4B								
Packaging 3 - 30 - B4B								
Packaging 3 - 31 - B4B								
				Plex 6/10/19 8:53 AM Dart.lajeunesse.marie				

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AUG 26 2019 8-59

6/10/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
295 DC - 1 - B4B	1 pcs	7/19/19	0.00 0.00	DC - 1 - B4B	AUG 27 2019
				DC - 2 - B4B	
300 QC 21 - FG	1 pcs	7/19/19	0.00 0.00	QC 21 - FG - 21	AUG 27 2019
				QC 21 - FG - 70	
				QC 21 - FG - 53	
Part Op 110 - (Skidtubes) ****VERIFY AND INSPECT THE MATERIAL PRIOR TO USE**** 1- remove fwd indexing ridge as per Descriptions: dwg D3274. Prepare for welding 2- weld fwd cap as per dwg D3274 and QSI004 AR Aluminum Rod Batch: <u>138989/1306</u> 3- grind fwd cap weld on top surface only 4- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end. 5-Drill Aft cap pilot hole using DT8025 6 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D and DT8742. Drill 3/16" pilot holes as per Dwg D3274 7 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch # 8 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end. 114 - (QC5- Inspect part completeness to step on W/O) 116 - (QC10- Inspect visual per QSI004- ground welds) 120 - (Chemical Conversion Coat per QSI005 4.1) 130 - (QC7-Inspect Chemical Conversion Coat) 150 - (Skidtubes) 1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg D3274 2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube 3-Bond web in place as per Dwg D3274 & QSI 015. (Adhere for 12 hours) 160 - (QC5- Inspect part completeness to step on W/O) 170 - (Skidtubes) 1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position. 2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2 OPEN HOLES TO .297" . Deburr 3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD END OF TUBE DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES) REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES 4- Countersink crossbolt spacer holes as per Dwg D3274 5- prepare for welding 180 - (QC5- Inspect part completeness to step on W/O) 190 - (Skidtubes) 1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod 3-Grind cross bolt welds flush as per Dwg D3274. ****INSPECT FOR PIN HOLES IN WELD**** 4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr. 200 - (QC5- Inspect part completeness to step on W/O) 210 - (QC10- Inspect visual per QSI004- ground welds) 220 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch 230 - (Spray Paint / NDT Room) Make sure Nut Plate Thread is protected using paint screw,. 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: <u>5189559</u> 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: <u>5192331</u> 240 - (QC14- Inspect Spray Paint) 244 - (Wing Walk as per dwg QSI005 4.4 Batch _____) 246 - (QC3- Inspect Part Finish) 250 - (Assemble as per dwg) 1-Install Nut Plate as per Dwg D3274. Apply LPS-PROCYON to Nut Plate and rivets. 260 - (QC5- Inspect part completeness to step on W/O) Inspect Nut Plate & Inserts 270 - (Assemble as per dwg) 1-Install wearpads as per Dwg D3274. 2-Install ring as per Dwg D3274 3-Inspect for foreign objects as per QSI 024 4-Install Aft Cap and seal with Sikaflex. Clean excess adhesive. 280 - (QC5- Inspect part completeness to step on W/O) 290 - (Identify as per dwg & Stock Location: _____) Location : FG073 295 - (Document Control) Photocopy bluefile & type labels per PPP D206-642- 541 CHG005 300 - (QC21- Final Inspection - Work Order Release) 4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 using DT10280 and deburr.					

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https://www.plexonline.com/849c84d2-7ef7-4ee5-95e8-eb50d12e192e/Plexus_Control/Report_Viewer_2.asp?URL=../Part/Job_Sheet.asp&Report=Tru... 7/8

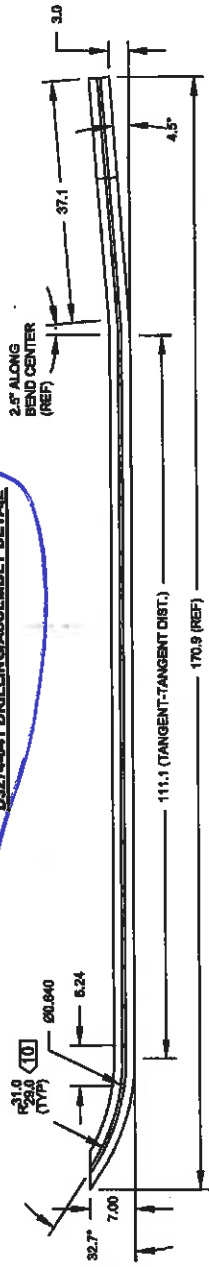
Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D3274-041BENT	Skidtube Assembly 206	1 pcs (1 ea)	110-Skidtubes - 1	51897463
D3285-1	Cap	1 pcs (1 ea)	110-Skidtubes - 1	5043738
D3282-041	Float Web (206L/407)	1 pcs (1 ea)	150-Skidtubes - 2 - B4B	5141855
D2649	Cross Bolt Spacer	12 pcs (12 ea)	190-Skidtubes - 4 - B4B	5156881
D3275-1	Cross Bolt Spacer	12 pcs (12 ea)	190-Skidtubes - 4 - B4B	5148269
ALS4-1032-130	Rivnut	78 Ea (78 ea)	250-Handfinish - 4-1-Assembly-B4B	5058257
CCR264SS3-3	Cherry Rivet	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	5095572
CR3212-4-03	Cherry Rivet	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	F1137886-0
D3415-041	Nut Plate	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	F147131
AN3C4A	Bolt	80 Ea (80 ea)	270-Handfinish - 4-2-Assembly-B4B	5192134
AN4C5A	Bolt	1 Ea (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5057496
D2646	Aft Cap	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5160607
D3413-1	O-Ring	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5207026
D3537-1	Wearpad	9 pcs (9 ea)	270-Handfinish - 4-2-Assembly-B4B	5204500
D3537-3	Wearpad	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5195631
D3672-1	Washer, Phenolic	2 pcs (2 ea)	270-Handfinish - 4-2-Assembly-B4B	F164M9
D4956-15	Wearplate Fwd	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5200829
D4956-23	Wearplate Center Fwd	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5201348
D4956-35	Wearplate Aft	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5201102
D4956-39	Wearplate Center Aft	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5261005
NAS1149C0332R	Washer	80 Ea (80 ea)	270-Handfinish - 4-2-Assembly-B4B	5193136
NAS1149C0463R	Washer	1 Ea (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5104372

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D3274-041BENT	1	3	0
	D3285-1	1	13	0
150-Skidtubes - 2 - B4B	D3282-041	1	1	0
190-Skidtubes - 4 - B4B	D2649	12	128	0
	D3275-1	12	104	0
250-Handfinish - 4-1-Assembly-B4B	ALS4-1032-130	78	7,437	0
	CCR264SS3-3	2	159	0
	CR3212-4-03	2	84	0
	D3415-041	1	9	0
	AN3C4A	80	858	0
270-Handfinish - 4-2-Assembly-B4B	AN4C5A	1	55	0
	D2646	1	32	0
	D3413-1	1	17	0
	D3537-1	9	59	0
	D3537-3	1	18	0
	D3672-1	2	1,677	0
	D4956-15	1	4	0
	D4956-23	1	10	0
	D4956-35	1	8	0
	D4956-39	1	1	0
	NAS1149C0332R	80	2,866	0
	NAS1149C0463R	1	279	0

Part Specifications

Specifications could not be found.

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D3274-041 BEND/DRILLING DETAIL

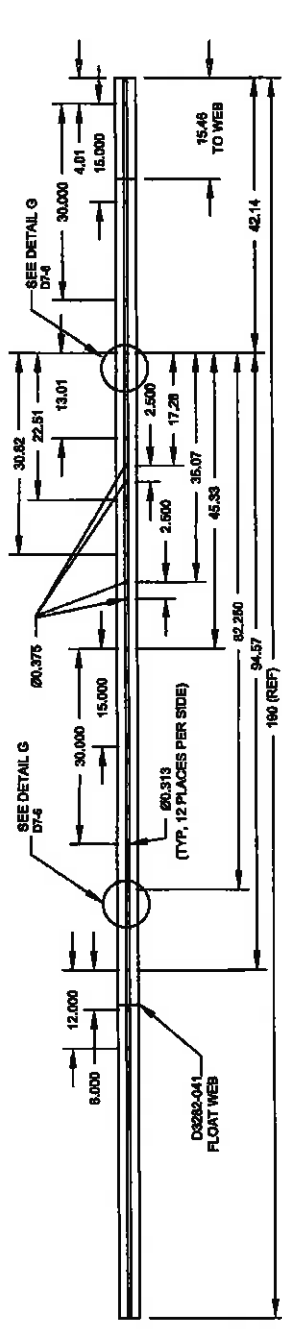


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2016-07-26

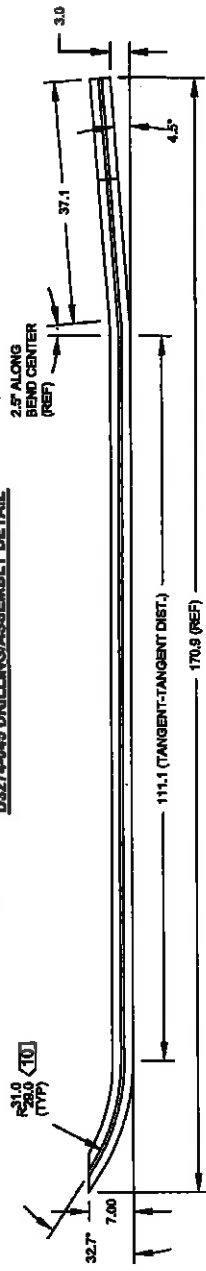


DESIGN	CP	DART AEROSPACE USA, INC	
DRAWN	RF	EUGENE, OR	
CHECKED	AK	DRAWING NO.	REV. G
INFO. APPR.	JLM	D3274	SHEET 3 OF 8
APPROVED	DS	TITLE	SCALE
DE APPR.	AK	SKIDTUBE ASSEMBLY	NTS
DATE	16.04.25	COPYRIGHT © 2004 BY DART AEROSPACE USA, INC This document is a confidential document, and is loaned to you for your internal use only. It is not to be distributed outside your organization. If you are not an authorized user, please do not use this document.	

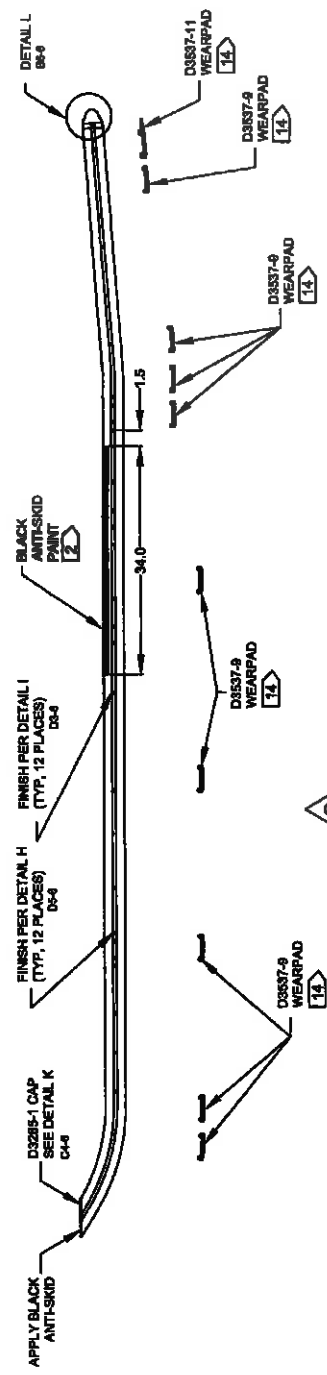
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2016-07-26



D3274-045 DRILLING/ASSEMBLY DETAIL



D3274-045 BENDING/DRILLING DETAIL



D3274-045 SKIDTUBE ASSEMBLY
(SEE DETAIL J FOR WEARSHOE INSTALLATION)

DESIGN	CP	AK	JLM	DS	DATE	16.04.25
DRAWN	RF	AK	JLM	DS		
CHECKED	AK	AK	JLM	DS		
INFO. APPR.	AK	AK	JLM	DS		
APPROVED	AK	AK	JLM	DS		
DE APPR.	AK	AK	JLM	DS		
DATE	16.04.25					

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R 2016-07-26

DART AEROSPACE USA, INC
EUGENE, OR

DRAWING NO. D3274

REV. G

SHEET 4 OF 8

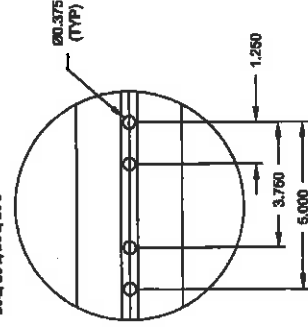
SCALE

NTS

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DETAIL A: DRILL DETAIL
D3415-041, D3415-042, D3415-043

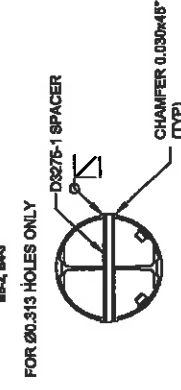


DETAIL B
D3415-041, D3415-042, D3415-043

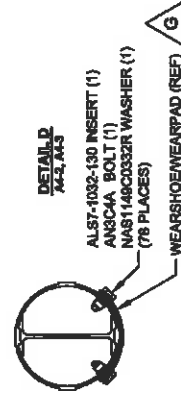


AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.313
HOLES ONLY:
1. CHAMFER HOLE 0.030x48"
2. INSERT D2648 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE TO Ø0.313±0.075 DEEP

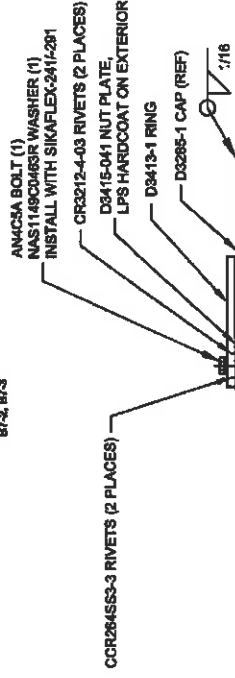
DETAIL C
D3415-041, D3415-042, D3415-043



DETAIL D
D3415-041, D3415-042, D3415-043



DETAIL E: END FINISHING DETAIL
D3415-041, D3415-042, D3415-043



DETAIL F
D3415-041, D3415-042, D3415-043



DETAIL F: NOTE
1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER D3415-041
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE
NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

REMOVE RIDGE
ON INSIDE OF
SKIDTUBE LEAVE
0.070 MIN.

ORIENTATION
OF D3415-041

Ø0.208 (2 PLACES)
DRILL PRIOR TO INSTALLING
D2648 CAP

BORE OUT END OF SKIDTUBE
TO 0.75 DEPTH AND 0.070 WALL

-041-043 DETAILS

RELEASED
R 2016-07-26

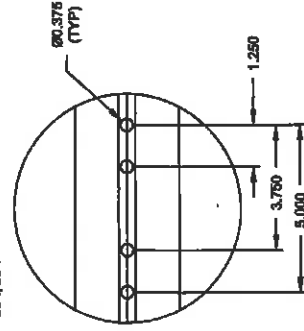
DESIGN	CP	RF	AK	JLM	DJS	DATE	16.04.25
DRAWN							
CHECKED							
INFG. APPR.							
APPROVED							
DE APPR.							
TITLE							
DRAWING NO.							
REV. G							
SHEET 5 OF 6							
SCALE							
NTS							

DART AEROSPACE USA, INC
EUGENE, OR

SKIDTUBE ASSEMBLY

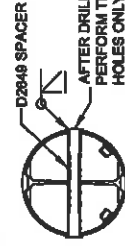
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DETAIL G: DRILL DETAIL
D4-4, D3-4



DETAIL H
D4-4

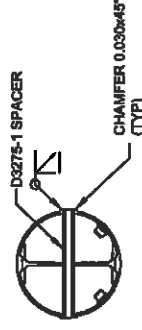
FOR Ø0.375 HOLES ONLY



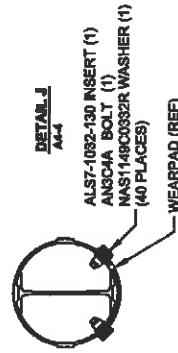
AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
2. INSERT D2848 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE TO Ø0.313x0.76 DEEP

DETAIL I
D4-4

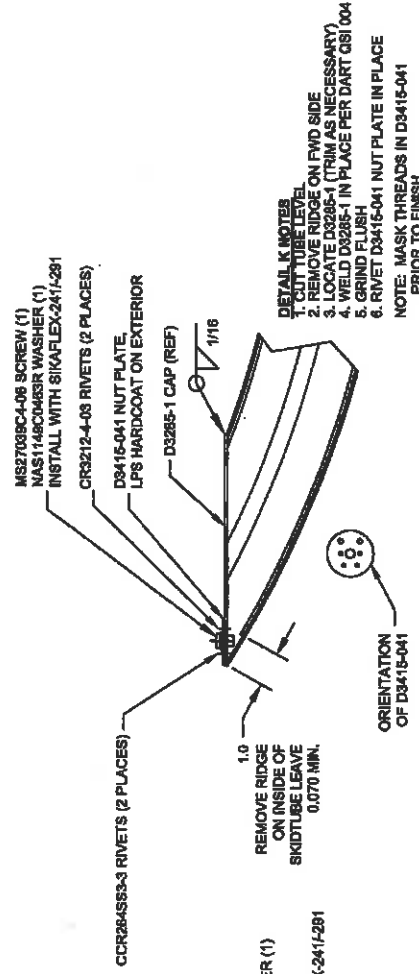
FOR Ø0.313 HOLES ONLY



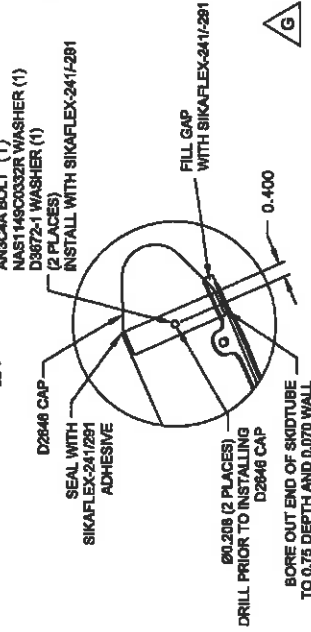
DETAIL J
D4-4



DETAIL K: END FINISHING DETAIL
D7-4



DETAIL L
D2-4



DETAIL K NOTES
1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART D31 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE
NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH



-045 DETAILS

RELEASED
R 2016-07-26

DESIGN	CP	RF	AK	JLM	DS	DATE	16.04.25
DRAWN							
CHECKED							
MFG. APPR.							
DE APPR.							
DATE							

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DESIGN	DRAWN	CHECKED	MFG. APPR.	DE APPR.	DATE	16.04.25

REV. G	SHEET 6 OF 8	SCALE	NTB
DART AEROSPACE USA, INC.	EUGENE, OR	DRAWING NO.	D3274
TITLE	SKIDTUBE ASSEMBLY	DATE	16.04.25



NCR No. _____

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐					
Date :	Sequence #:	QTY Affected :		MRB (QS1042)					
Description Work Order Deviation		Disposition							
Root Cause Operator Manufacturing Process Equip/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors		FAULT CATEGORY Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled Other/Details: Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread							
						Completed By			
						Lead hand / Supervisor			
		QC / QA Coordinator							